

Date: Tuesday, 16/10/2007 10:16:59 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	350/212/130 BASKET LID
Job Number	35177B	Part Number	D2512
Estimate Number	10193	Drawing Number	D2512 REV D2
P.O. Number		Project Number	N/A
This Issue	16/10/2007	Drawing Revision	D2
Prsht Rev.	NC	Material	
First Issue	/ /	Due Date	23/10/2007
Previous Run	35105B	Qty:	1
Written By		Um:	Each
Checked & Approved By			
Comment	Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21	EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	J.J.L. 07/10/21
		Pick: 3/4"x3/4" 304/316 SS tube .063" wall	
		Batch: M 105604	
2.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	J.J.L. 07/10/21
		Pick: Qty Part Number Description Batch	
		1 D3166-3 Basket Hoop B34424	
3.0	D2506	Placard	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	J.J.L. 07/10/23
		Pick: Qty Part Number Description Batch	
		1 D2506 Label Plate B33449	
4.0	D23271	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	J.J.L. 07/10/21
		Pick: Qty Part Number Description Batch	
		2 D2327-1 Bushing B31693	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/10/2007 10:16:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 35177B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22321 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-1	Hinge plate	<u>B 31608</u>

J.J.L. 07/10/23

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	<u>B 34445</u>

J.J.L. 07/10/23

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	<u>M 105913</u>

J.J.L. 07/10/24

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

J.J.L. 07/10/25

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

J.J.L. 07-10-26 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/10/2007 10:16:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 35177B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 07-10-26 (1)

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07 10 28

(1)

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

SPRAY ~~07/10/28~~
Batch: M106030

M 07 10 28 (1)

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 07/10/29

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

M 07/10/29

15.0 QC21 FINAL INSPECTION/W/O RELEASE



07.10.31
AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.10.31

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

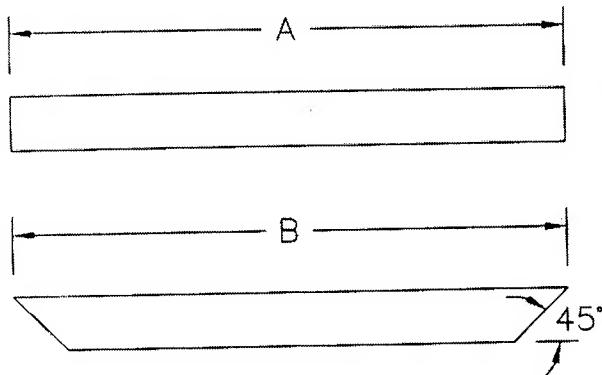


DESIGN BW	DRAWN BY <i>RP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE NTS
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	03.01.20	ADD D2012-117 FOR D130-701-041	
D2	04.09.20	TACK WELD PNP-5 GRID AREA	

RELEASED
01.04.27 *RP*

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

Copyright © 1995 by DART AEROSPACE LTD

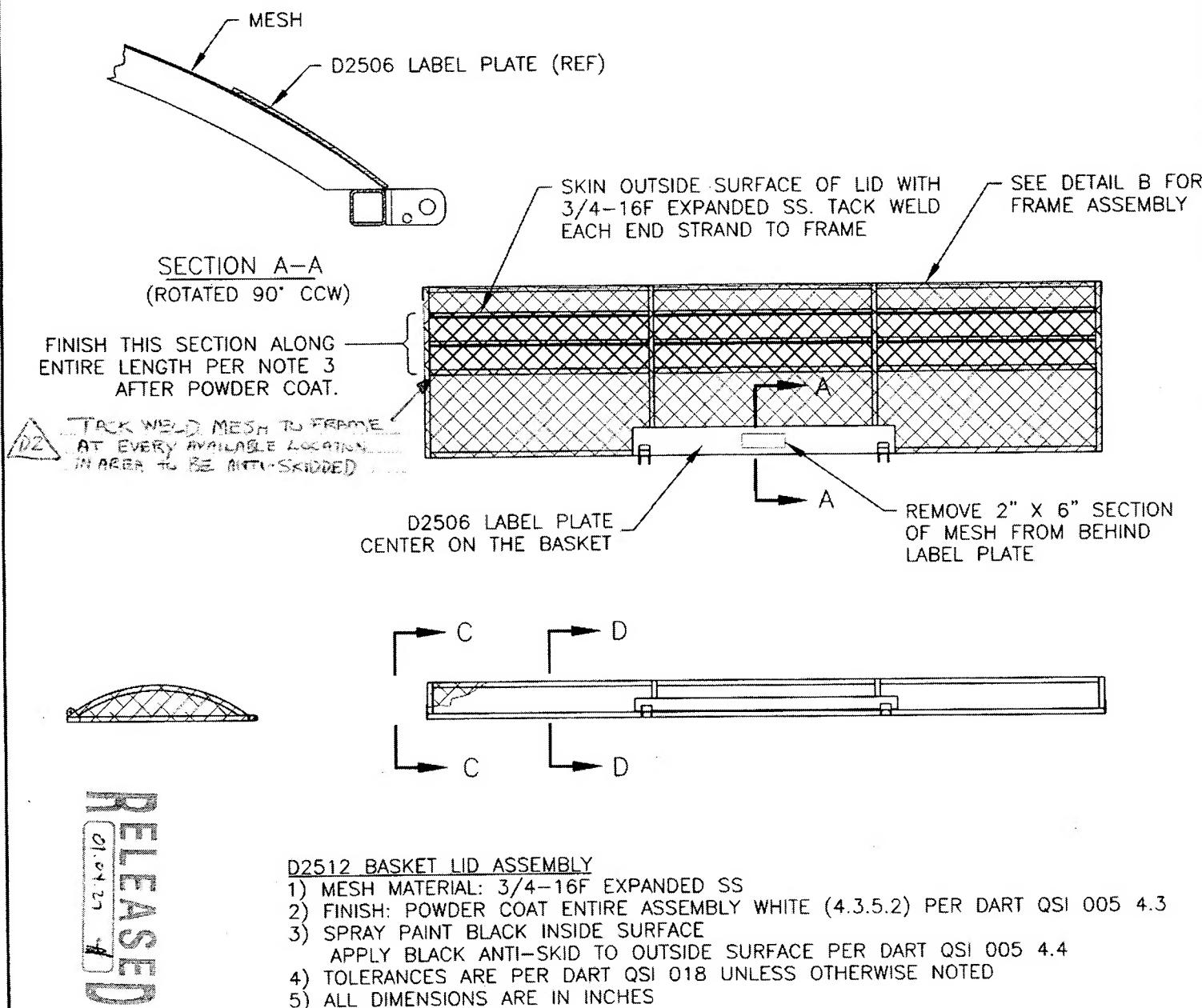
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
01.04.19

DART		DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA		REV. D	
DESIGN	DRAWN BY	COPYRIGHT	SHEET 2 OF 4
BW	APPROVED	D	SCALE
CHECKED	DATE	D2512	
	01.04.19	TITLE	
BASKET LID ASSEMBLY (350/212)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

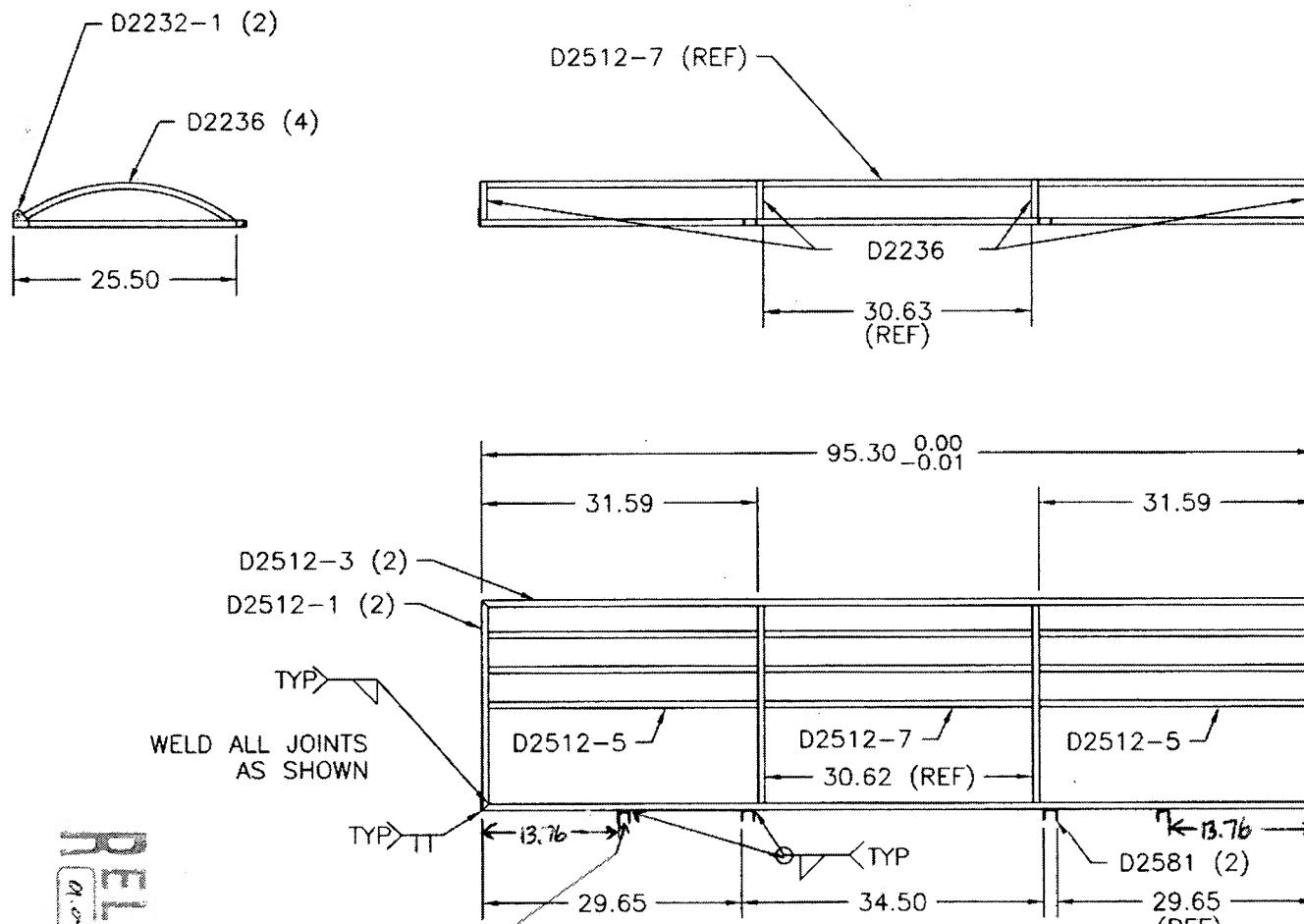
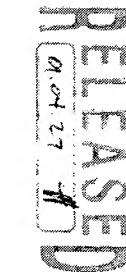
NOTE: Date & initial all entries



DESIGN		DART AEROSPACE LTD	
BY		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWN BY	SHEET 3 OF 4	
<i>H</i>	<i>JP</i>	REV. D	
APPROVED	DRAWING NO.	SCALE	
<i>H</i>	D2512	1:20	
DATE	TITLE		
01.04.19	BASKET LID ASSEMBLY (350/212)		

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 1995 by DART AEROSPACE LTD



PLACES) DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

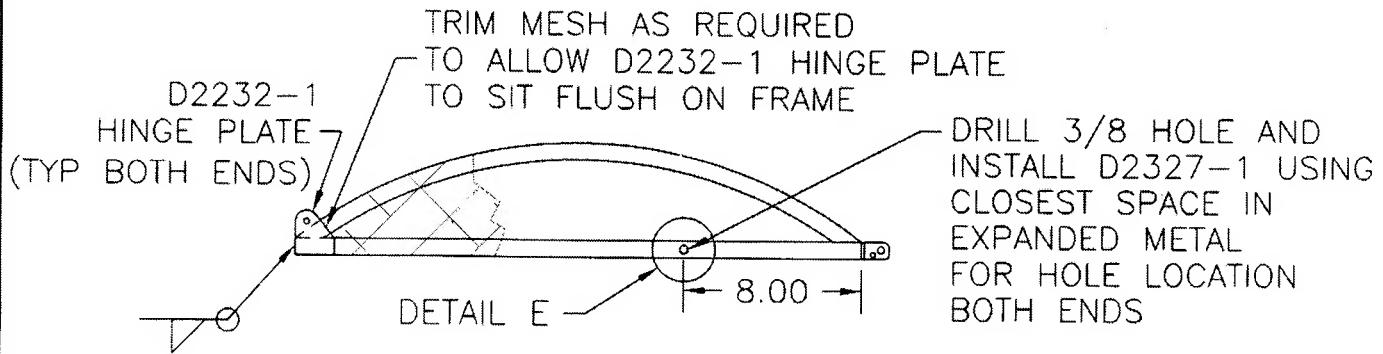
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
•								

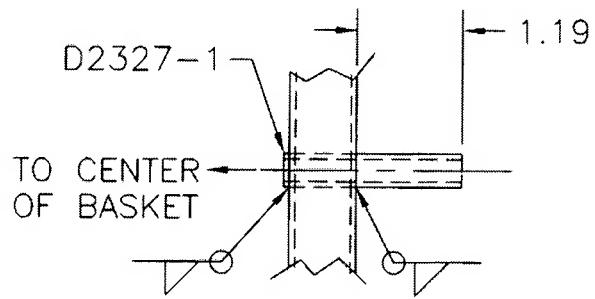
NOTE: Date & initial all entries



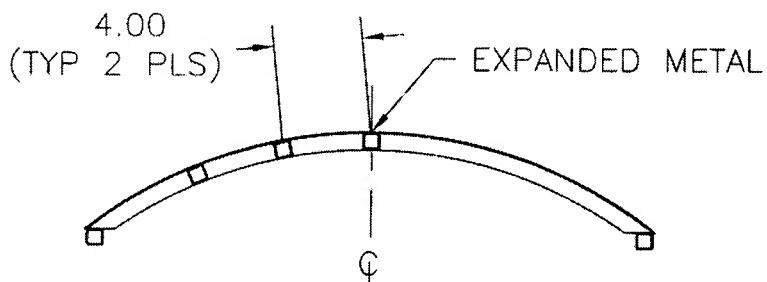
DESIGN BW	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



RELEASED
01.04.27 *CH*

SECTION D-D SAME BOTH CENTER RIBS

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries